



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

Re-Print

D206-642-541
Job Sheet 195720



Part No: D206-642-541

Job Qty: 1 pcs

Part Name: Repl.Skid.,High Gear,Std Wearplates Fits LH/RH, DART Tri-Bag Float Comp.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/30/19

Job Tracking No:

Created By: Kimberley Guerin

Due Date: 7/5/19

Description:

Note: DWG REV G IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC IPP Rev:F 08-06-02 add comment DD verified by:EC IPP Rev:G 08-10-09 revise details DD verified by:EC IPP Rev:H 13.09.05 CHG004/ ECN13-634 DD VERF:JLM IPP REV:I 14.04.28 AS PER ECN14-520 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	7/5/19		0.00	2.17	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
114	QC 5	1 pcs	7/5/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22	DAS	
							QC 5 - 24	24	
							QC 5 - 3	9-89	
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
116	QC 10	1 pcs	7/5/19		0.00	0.00	QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 10 - 10		
							QC 10 - 18	DAS	
							QC 10 - 24	24	
							QC 10 - 43	9-89	

TF
BE

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24
9-89

JUL 02 2019

JUL 02 2019



Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL.: 1 613 632-5200
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Container No: S191284



Part: D206-642-541

Job No: 195720

Serial No/Batch: S191284

Revision:

Inspector:

Exp Date:

Instructions: FAA STC SA00475SE 18/10/17, TC STC SH98-4 Issue 2, EASA STC

				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
120	Handfinish - 1-1 Chemical- B4B	1	7/5/19	0.00 0.68	Handfinish - 1 - 1 - B4B
	pcs				Handfinish - 1 - 2 - B4B
					Handfinish - 1 - 3 - B4B
					Handfinish - 1 - 4 - B4B
					Handfinish - 1 - 5 - B4B
					Handfinish - 1 - 6 - B4B
					Handfinish - 1 - 7 - B4B
					Handfinish - 1 - 8 - B4B
					Handfinish - 1 - 9 - B4B
					Handfinish - 1 - 10 - B4B
					Handfinish - 1 - 11 - B4B
					Handfinish - 1 - 12 - B4B
					Handfinish - 1 - 13 - B4B
					Handfinish - 1 - 14 - B4B
					Handfinish - 1 - 15 - B4B
					Handfinish - 1 - 16 - B4B
					Handfinish - 1 - 17 - B4B
					Handfinish - 1 - 18 - B4B
					Handfinish - 1 - 19 - B4B
					Handfinish - 1 - 20 - B4B
					Handfinish - 1 - 21 - B4B
					Handfinish - 1 - 22 - B4B
130	QC 7	1	7/5/19	0.00 0.00	QC 7 - 10
	pcs				QC 7 - 13
					QC 7 - 14
					QC 7 - 15
					QC 7 - 17
					QC 7 - 18
					QC 7 - 19
					QC 7 - 2
					QC 7 - 28
					QC 7 - 3
					QC 7 - 30
					QC 7 - 34
					QC 7 - 36
					QC 7 - 37
					QC 7 - 41
					QC 7 - 47
					QC 7 - 48
					QC 7 - 51
					QC 7 - 58
					QC 7 - 59
					QC 7 - 60
					QC 7 - 9
					QC 7 - 68

JUL 03 2019

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					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
150 Skidtubes - 2 - B4B	1 pcs	7/5/19	0.00 2.08	Skidtubes - 1 - B4B		DJ
				Skidtubes - 2 - B4B		
				Skidtubes - 3 - B4B		
				Skidtubes - 4 - B4B		TF
				Skidtubes - 5 - B4B		
				Skidtubes - 6 - B4B		
				Skidtubes - 7 - B4B		
160 QC 5	1 pcs	7/5/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		BE
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40		
170 Skidtubes - 3 - B4B	1 pcs	7/5/19	0.00 2.17	Skidtubes - 1 - B4B		
				Skidtubes - 2 - B4B		
				Skidtubes - 3 - B4B	#1 MGC	
				Skidtubes - 4 - B4B		TF
				Skidtubes - 5 - B4B		
				Skidtubes - 6 - B4B		
				Skidtubes - 7 - B4B		
180 QC 5	1 pcs	7/5/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		BE
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40		
190 Skidtubes - 4 - B4B	1 pcs	7/5/19	0.00 2.75	Skidtubes - 1 - B4B		
				Skidtubes - 2 - B4B		
				Skidtubes - 3 - B4B		
				Skidtubes - 4 - B4B		TF
				Skidtubes - 5 - B4B		BE
				Skidtubes - 6 - B4B		

200 QC 5	1 pcs	7/5/19	0.00 0.00	Skid tubes - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	JUL 24 2019 DAS 68
				QC 5 - 9	9-89
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
210 QC 10	1 pcs	7/5/19	0.00 0.00	QC 10 - 43	
				QC 10 - 50	JUL 24 2019 DAS 50
				QC 10 - 58	9-89
				QC 10 - 9	
				QC 10 - 9	
220 Handfinish - 2-1 Pressure- B4B	1 pcs	7/5/19	0.00 0.45	Handfinish - 2 - 1 - B4B	
				Handfinish - 2 - 2 - B4B	
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
230 Spray Paint - 2 - B4B	1 pcs	7/5/19	0.00 0.40	Spray Paint - 1 - B4B	AL 17-7-28
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
240 QC 14	1 pcs	7/5/19	0.00 0.00	QC 14 - 15	AL 19-8-26
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
				QC 14 - 24	
244 Handfinish - 3-1- WingWalk- B4B	1 pcs	7/5/19	0.00 0.50	Handfinish - 3 - 1 - B4B	AL 19-8-26
				Handfinish - 3 - 2 - B4B	
				Handfinish - 3 - 3 - B4B	
				Handfinish - 3 - 4 - B4B	
				Handfinish - 3 - 5 - B4B	
246 QC 3	1 pcs	7/5/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	

6/4/2019

[Dart Hawkesbury] Job Sheet - Leroux, Jason

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						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	3 FEB 19-08-26
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
250	Handfinish - 4-1-Assembly-B4B	1	7/5/19	0.00	0.45	Handfinish - 4 - 1 - B4B	RL 14-E-29
		pcs				Handfinish - 4 - 10 - B4B	
						Handfinish - 4 - 11 - B4B	
						Handfinish - 4 - 12 - B4B	
						Handfinish - 4 - 13 - B4B	
						Handfinish - 4 - 14 - B4B	
						Handfinish - 4 - 15 - B4B	
						Handfinish - 4 - 2 - B4B	
						Handfinish - 4 - 3 - B4B	
						Handfinish - 4 - 4 - B4B	
						Handfinish - 4 - 5 - B4B	
						Handfinish - 4 - 6 - B4B	
						Handfinish - 4 - 7 - B4B	
						Handfinish - 4 - 8 - B4B	
						Handfinish - 4 - 9 - B4B	
260	QC 5	1	7/5/19	0.00	0.00	QC 5 - 10	
		pcs				QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
270	Handfinish - 4-2-Assembly-B4B	1	7/5/19	0.00	0.68	Handfinish - 4 - 1 - B4B	
		pcs				Handfinish - 4 - 10 - B4B	
						Handfinish - 4 - 11 - B4B	
						Handfinish - 4 - 12 - B4B	
						Handfinish - 4 - 13 - B4B	
						Handfinish - 4 - 14 -	

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AUG 26 2019

Plex 6/4/19 4:21 PM dart.leroux.jason

				B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
280 QC 5	1	7/5/19	0.00 0.00	QC 5 - 10	
	pcs			QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
290 Packaging 3-1 - Stock - B4B	1	7/5/19	0.00 0.00	Packaging 3 - 1 - B4B	
	pcs			Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	

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					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	DAG
					Packaging 3 - 36 - B4B	21
295 DC - 1 - B4B	1	7/5/19	0.00 0.00	DC - 1 - B4B	9-09	SEP 1 1 2019
	pcs			DC - 2 - B4B		
300 QC 21 - FG	1	7/5/19	0.00 0.00	QC 21 - FG - 21		SEP 1 1 2019
	pcs			QC 21 - FG - 70	DAG	
				QC 21 - FG - 53	21	

Part Op 110 - (Skidtubes) ****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE**** 1- remove fwd indexing ridge as per
 Descriptions: dwg D3274. Prepare for welding 2- weld fwd cap as per dwg D3274 and QSI004 AR Aluminum Rod
 Batch: 138987/139011 3- grind fwd cap weld on top surface only 4- Cut AFT end of tube at 170.9" as per dwg D3274
 and deburr end. 5-Drill Aft cap pilot hole using DT8025 6 -Cleco DT8025 in position and install pilot hole drill Jig
 DT8742A,B,C,D and DT8742. Drill 3/16" pilot holes as per Dwg D3274 7 -Remove inner indexing ridge on aft end of
 skidtube as per Dwg D3274 scribe batch # 8 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.
 114 - (QC5- Inspect part completeness to step on W/O)
 116 - (QC10- Inspect visual per QSI004- ground welds)
 120 - (Chemical Conversion Coat per QSI005 4.1)
 130 - (QC7-Inspect Chemical Conversion Coat)
 5174342
 08/12/19 150 - (Skidtubes) 1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274 2-Deburr crossbolt spacer holes
 as per Dwg D3274 and blow out chips from inside the tube 3-Bond web in place as per Dwg D3274 & QSI 015. (Adhere
 for 12 hours)
 160 - (QC5- Inspect part completeness to step on W/O)
 170 - (Skidtubes) 1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt
 spacer holes to maintain web position. 2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2 OPEN HOLES
 TO .297" . Deburr 3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE DEBURR
 INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES) REMOVE ANY FOREIGN OBJECTS INSIDE OF
 TUBES 4- Countersink crossbolt spacer holes as per Dwg D3274 5- prepare for welding
 180 - (QC5- Inspect part completeness to step on W/O)
 190 - (Skidtubes) 1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back
 drill each hole before welding the other side. Use aluminum rod 3-Grind cross bolt welds flush as per Dwg D3274.
 ****INSPECT FOR PIN HOLES IN WELD**** 4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.
 200 - (QC5- Inspect part completeness to step on W/O)
 210 - (QC10- Inspect visual per QSI004- ground welds)
 220 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do
 not acid etch
 230 - (Spray Paint / NDT Room) Make sure Nut Plate Thread is protected using paint screw,. 1- PRIME AS PER DWG
 AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 5189559 2- PAINT WHITE AS PER DWG AND
 QSI 005 4.2 PAINT BATCH: 5192331
 240 - (QC14- Inspect Spray Paint)
 244 - (Wing Walk as per dwg QSI005 4.4 Batch 5185147)
 246 - (QC3- Inspect Part Finish)
 250 - (Assemble as per dwg) 1-Install Nut Plate as per Dwg D3274. Apply LPS-PROCYON to Nut Plate and rivets.
 260 - (QC5- Inspect part completeness to step on W/O) Inspect Nut Plate & Inserts
 270 - (Assemble as per dwg) 1-Install wearpads as per Dwg D3274. 2-Install ring as per Dwg D3274 3-Inspect for foreign
 objects as per QSI 024 4-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.
 280 - (QC5- Inspect part completeness to step on W/O)
 290 - (Identify as per dwg & Stock Location: _____) Location : FG073
 295 - (Document Control) Photocopy bluefile & type labels per PPP D206-642- 541 CHG005
 300 - (QC21- Final Inspection - Work Order Release) 4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 using
 DT10280 and deburr.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3274-041BENT	Skidtube Assembly 206	1 pcs (1 ea)	110-Skidtubes - 1	5109144
D3285-1	Cap	1 pcs (1 ea)	110-Skidtubes - 1	5043738
D3282-041	Float Web (206L/407)	1 pcs (1 ea)	150-Skidtubes - 2 - B4B	5191355
D2649	Cross Bolt Spacer	12 pcs (12 ea)	190-Skidtubes - 4 - B4B	5156881x2 5188442x10
D3275-1	Cross Bolt Spacer	12 pcs (12 ea)	190-Skidtubes - 4 - B4B	5148269
ALS4-1032-130	Rivnut	78 Ea (78 ea)	250-Handfinish - 4-1-Assembly-B4B	5057257
CCR264SS3-3	Cherry Rivet	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5099573
CR3212-4-03	Cherry Rivet	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	FM1137896-0
D3415-041	Nut Plate	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5197646
AN3C4A	Bolt	80 Ea (80 ea)	270-Handfinish - 4-2-Assembly-B4B	5192134
AN4C5A	Bolt	1 Ea (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5057496
D2646	Aft Cap	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5160607
D3413-1	O-Ring	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5207076
D3537-1	Wearpad	9 pcs (9 ea)	270-Handfinish - 4-2-Assembly-B4B	5204500
D3537-3	Wearpad	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5195631
D3672-1	Washer, Phenolic	2 pcs (2 ea)	270-Handfinish - 4-2-Assembly-B4B	5164009
D4956-15	Wearplate Fwd	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5200829
D4956-23	Wearplate Center Fwd	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5201340
D4956-35	Wearplate Aft	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5201007
D4956-39	Wearplate Center Aft	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5201108
NAS1149C0332R	Washer	80 Ea (80 ea)	270-Handfinish - 4-2-Assembly-B4B	5193138
NAS1149C0463R	Washer	1 Ea (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5104323

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D3274-041BENT	1	5	0
	D3285-1	1	15	0
150-Skidtubes - 2 - B4B	D3282-041	1	1	0
190-Skidtubes - 4 - B4B	D2649	12	70	0
	D3275-1	12	104	0
250-Handfinish - 4-1-Assembly-B4B	ALS4-1032-130	78	7,481	0
	CCR264SS3-3	2	159	0
	CR3212-4-03	2	84	0
	D3415-041	1	9	0
270-Handfinish - 4-2-Assembly-B4B	AN3C4A	80	958	0
	AN4C5A	1	55	0
	D2646	1	32	0
	D3413-1	1	17	0
	D3537-1	9	59	0
	D3537-3	1	18	0
	D3672-1	2	1,677	0
	D4956-15	1	4	0
	D4956-23	1	10	0
	D4956-35	1	8	0
	D4956-39	1	1	0
	NAS1149C0332R	80	2,970	0
	NAS1149C0463R	1	279	0

Part Specifications

Specifications could not be found.

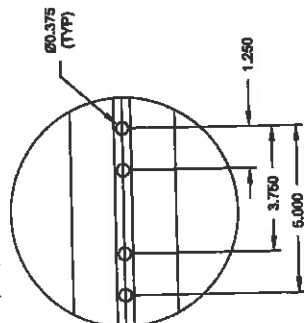
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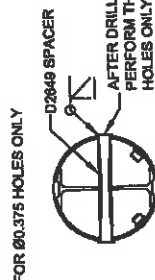
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DETAIL A: DRILL DETAIL
D4-2, D4-3, D4-4, D4-5, D4-6

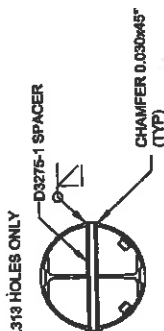


DETAIL B
B4-2, B4-3



FOR Ø0.375 HOLES ONLY

DETAIL C
B4-2, B4-3

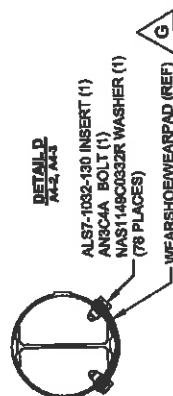


FOR Ø0.313 HOLES ONLY

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375
HOLES ONLY:

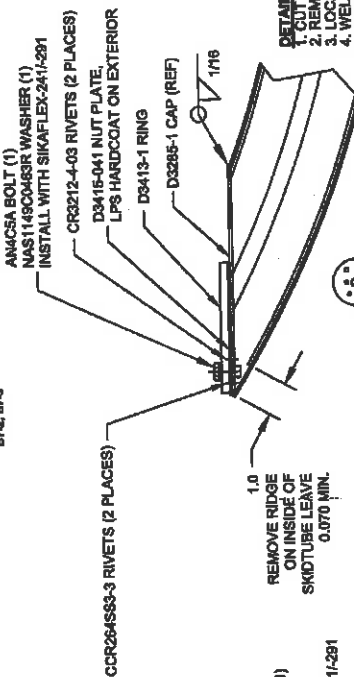
1. CHAMFER HOLE 0.030x45°
2. INSERT D2648 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C-BORE TO Ø0.313x0.75 DEEP

DETAIL D
B4-2, B4-3



- ALS7-1032-130 INSERT (1)
- ANSC44 BOLT (1)
- NAS1148C0332R WASHER (1)
- (78 PLACES)
- WEARSHOEWEARPAD (REF)

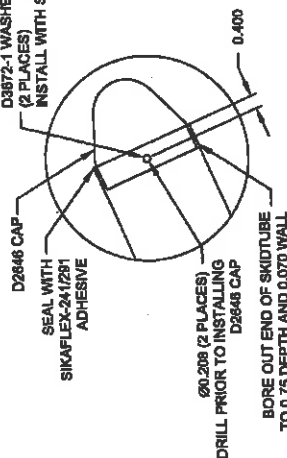
DETAIL E: END FINISHING DETAIL
B7-2, B7-3



- ANSC44 BOLT (1)
- NAS1148C0433R WASHER (1)
- INSTALL WITH SIKAFLEX-241/291
- CR2312-4-03 RIVETS (2 PLACES)
- D3415-041 NUT PLATE
- LPS HARDCOAT ON EXTERIOR
- D3413-1 RING
- D3285-1 CAP (REF)
- 1/16
- 1.0
- REMOVE RIDGE
ON INSIDE OF
SKIDTUBE LEAVE
0.070 MIN.
- ORIENTATION
OF D3415-041

- DETAIL E NOTES**
1. REMOVE RIDGE ON FWD SIDE
 2. LOCATE D3285-1 (TRIM AS NECESSARY)
 3. WELD D3285-1 IN PLACE PER DART Q81 004
 4. GRIND FLUSH
 5. RIVET D3415-041 NUT PLATE IN PLACE
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

DETAIL F
B4-2, B4-3



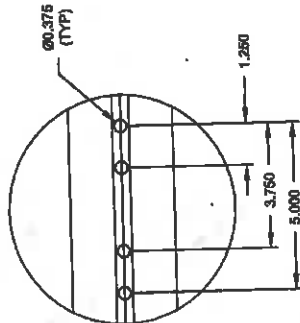
- ANSC44 BOLT (1)
- NAS1148C0332R WASHER (1)
- D3872-1 WASHER (1)
- INSTALL WITH SIKAFLEX-241/291
- D2646 CAP
- SEAL WITH
SIKAFLEX-241/291
ADHESIVE
- Ø0.208 (2 PLACES)
- DRILL PRIOR TO INSTALLING
D2648 CAP
- BORE OUT END OF SKIDTUBE
TO 0.75 DEPTH AND 0.070 WALL
- 0.400

DESIGN	CP	RF	AK	JLM	D3	DATE	16.04.25
DRAWN							
CHECKED							
INFG. APPR.							
APPROVED							
DE APPR.							
TITLE	SKIDTUBE ASSEMBLY						
SCALE	NTS						
REV. G	SHEET 5 OF 8						
DRAWING NO.	D3274						
DART AEROSPACE USA, INC.	EUGENE, OR						

RELEASED
2016-07-26

-041-043 DETAILS

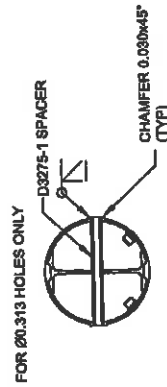
DETAIL G: DRILL DETAIL
86-4, D3-4



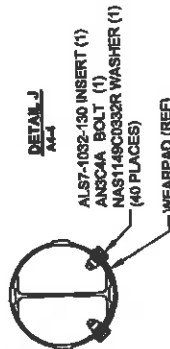
DETAIL H
86-4



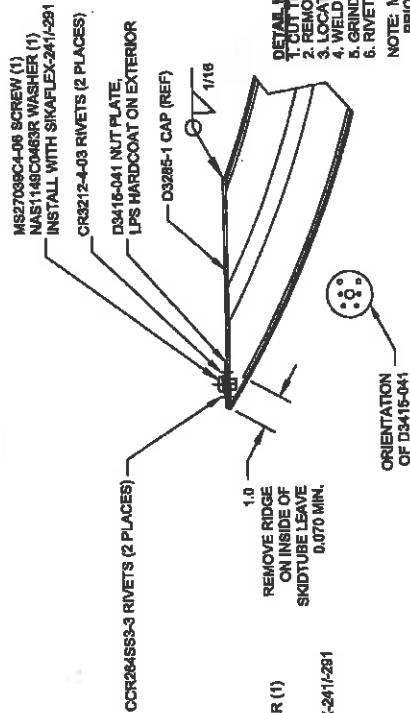
DETAIL I
86-4



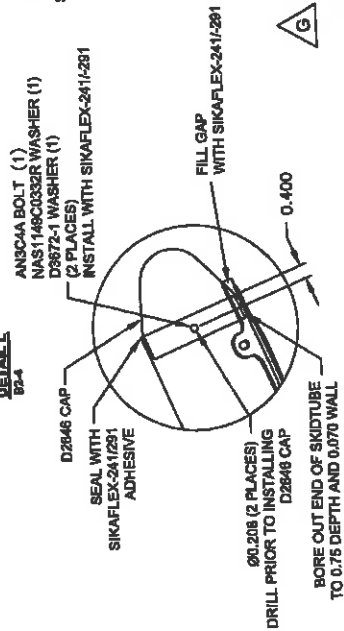
DETAIL J
A4-4



DETAIL K: END FINISHING DETAIL
87-4



DETAIL L
86-4



DETAIL K NOTES
1. RIVET D3275-1
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER PART Q81 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE
NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH

DESIGN	CP	RF	AK	JLM	DS	DE APPR.	DATE
DRAWN							16.04.25
CHECKED							
MFG. APPR.							
APPROVED							
DESIGN							
TITLE							
SCALE							
REV. G							
SHEET 8 OF 8							
NTS							

-045 DETAILS

RELEASED
2016-07-26

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EUGENE, OR
DRAWING NO. D3274
TITLE SKIDTUBE ASSEMBLY
SCALE NTS
DATE 16.04.25
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PAGE 1 OF 1

Description: REPLACEMENT FLOAT SKIDTUBE, LH/RH

H:\Forms\Engineer\Approved Eng Online\CHGREC revB